

### ABSTRACT

A method and apparatus associated with forming a blade attachment slot in a gas turbine engine turbine disk. The method further includes a full-form finish honing that produces a blade attachment slot free of broach ripples. The apparatus includes a broach carrier and cutting inserts  
5 coupled to the support. The cutting inserts are interchangeable and can be replaced when worn or damaged. The carrier has integral support members for bracing the cutting inserts. Each cutting insert has lateral support surfaces to prevent the cutting insert from moving laterally within the cutting insert assembly. Further, the broach assembly can be used as a replacement for damaged portions of a broach. The cutting inserts can be manufactured utilizing a fixtured EDM process.